

Work Order ID 60248

Tuesday, June 29, 2010 3:48:20 PM

Page 1

Item ID: D3813-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Assembly, Upper Door

Start Date: 6/29/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 6/29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3813

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install helicoils as per Dwg D3813 2-Install Ball joint and nut loosely as per Dwg D3813

⇒ m-d

W/07/13

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Solo 7/14

②

120

Identify as per dwg & Stock Location: 089

0.00



Packaging

Memo

0.00

Packaging

Rep/14 ②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60248

Page 2

Tuesday, June 29, 2010 3:48:20 PM

Item ID: D3813-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Assembly, Upper Door

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

100715
MF
10-7-14

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, June 29, 2010 3:48:23 PM

Work Order ID: 60248

Parent Item: D3813-041

Parent Item Name: Hinge Assembly, Upper Door





Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3518-3  Stainless Steel Ball Joint Rod End		Manufactured	No			100	Each	14.0000	1	2			
<div> <div>Location</div> <div>ST067</div> <div>39029 ✓</div> <div>53454 ✓</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>6</div> <div>8</div> </div> <div> <div>Loc Code</div> </div>													
D3813-1  Hinge, Upper Door		Manufactured	No			100	Each	10.0000	1	2			
<div> <div>Location</div> <div>ST090</div> <div>52288 ✓</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> </div>													
MS124738  Heli-Coil 3/8-24 unf		Purchased	No			100	Each	45.0000	1	2			
<div> <div>Location</div> <div>ST314</div> <div>113368 ✓</div> </div> <div> <div>Loc Qty</div> <div>45</div> <div>45</div> </div> <div> <div>Loc Code</div> </div>													
NAS509-6  Nut		Purchased	No			100	Each	20.0000	1	2			
<div> <div>Location</div> <div>ST280</div> <div>113537 ✓</div> </div> <div> <div>Loc Qty</div> <div>20</div> <div>20</div> </div> <div> <div>Loc Code</div> </div>													

2x m-l 10/07/08

2x m-l 10/07/08

2x m-l 10/07/08

2x m-l 10/07/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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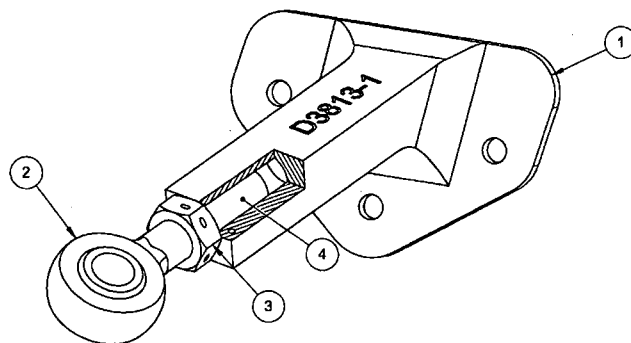
NOTE: Date & initial all entries

SHEET 1 OF 4

RETURN TO

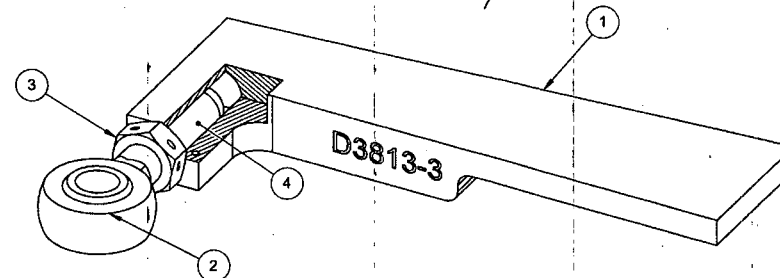
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *60248*
D3810-G-29



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-043 HINGE ASSY, LOWER DOOR

RELEASED
04/01/13

A	NEW ISSUE	DATE	08.11.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3813**

TITLE **HINGE**

REV. A
SHEET 1 OF 4
SCALE
NTS

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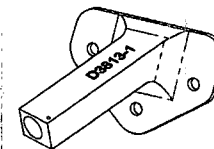
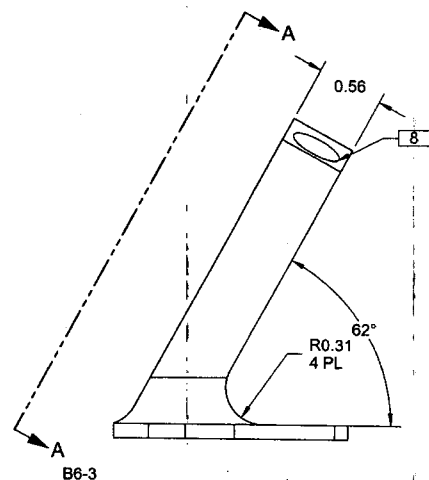
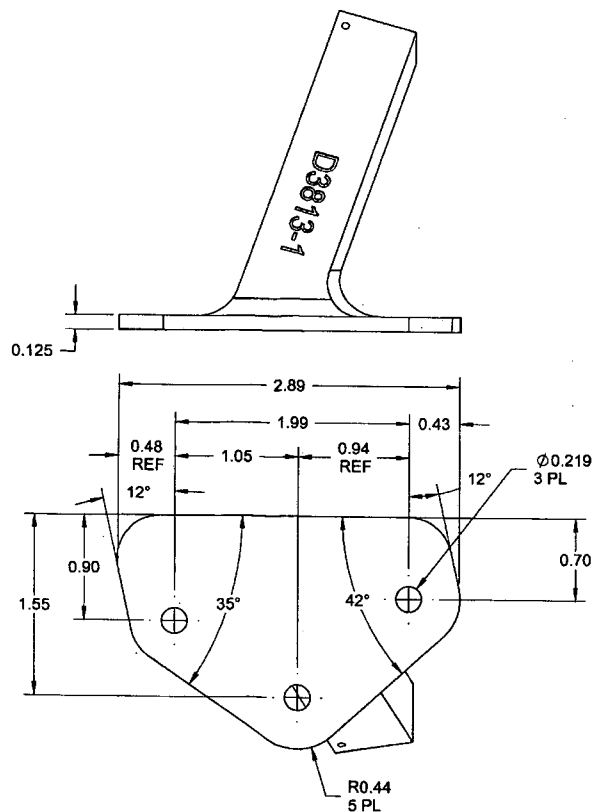
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



wlo 402418

D3813-1 HINGE, UPPER DOOR

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6081T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.14 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
09/01/13

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3813	SHEET 2 OF 4
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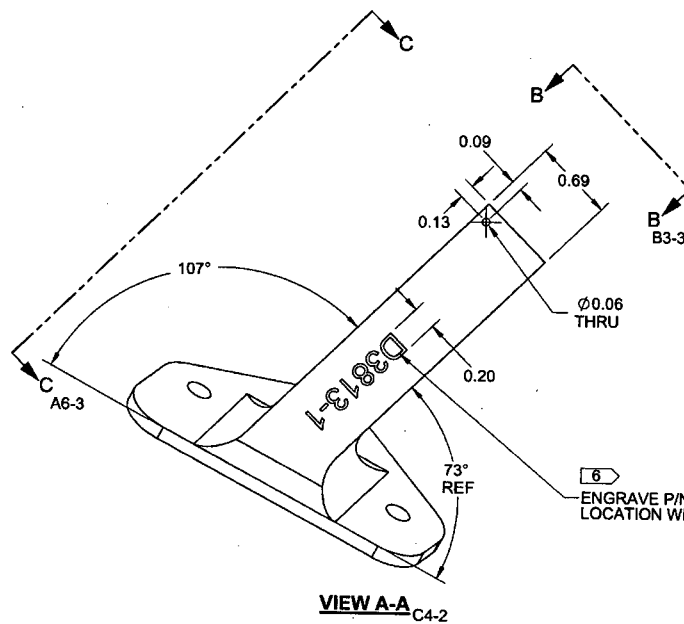
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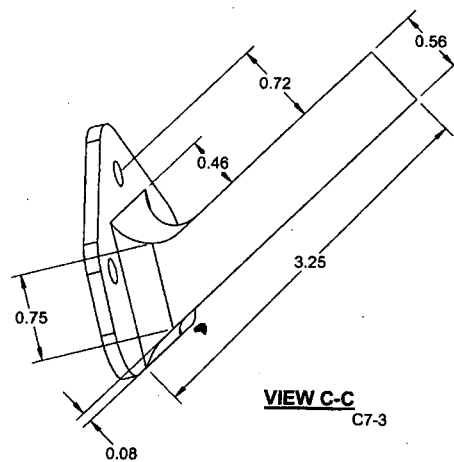
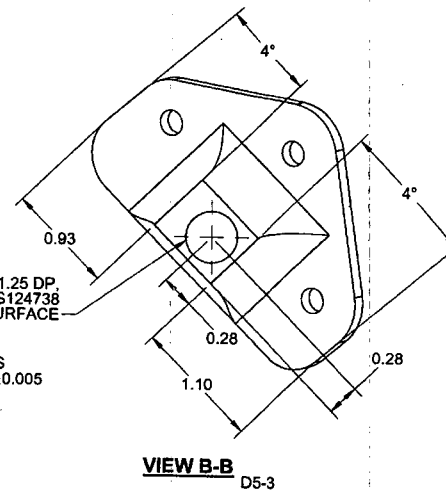
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Ø0.391 X 1.25 DP.
INSTALL HELICOIL MS124738
FLUSH WITH SURFACE

6
ENGRAVE P/N TO DEPTH OF 0.005 IN THIS
LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3813-1 HINGE, UPPER DOOR

wb 60248

RELEASED
09/07/13

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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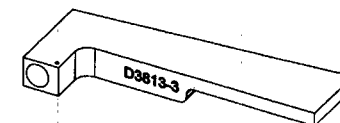
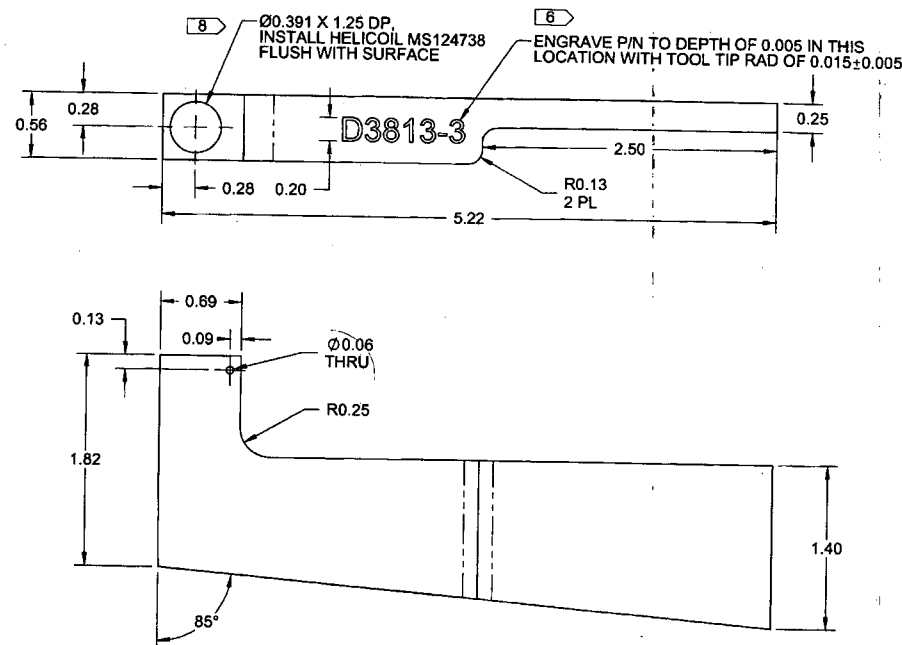
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NOTE: Date & initial all entries



D3813-3 HINGE, LOWER DOOR

W060248

RELEASED
07/07/12 MDP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.24 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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CHECKED		DRAWING NO.	REV. A
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